

Date: Friday, 7/4/2008 8:47:06 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FITTING
Job Number : 40257	
Estimate Number : 11396	
P.O. Number :	Part Number : D32993
This Issue : 7/4/2008 S.O. No. :	Drawing Number : D3299 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 35139	Material :
Written By :	Due Date : 7/30/2008 Qty: 6 Um: Each
Checked & Approved By : <u>08 07.04</u>	
Comment : Est: A 04.10.04 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6H1000	6061-T6 1" HexBar
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Comment: Qty.: 0.1925 f(s)/Unit Total: 1.1548 f(s)
6061-T6 1" HexBar
Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.00" Hex
(M6061T6H1.000)
Identify as D3299-3
Batch: M105238

mmf 08/07/11

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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⑧

Comment: Machine as per Folio FA452 and Dwg D3299
Deburr

mmf 08/07/11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



⑧

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 08/07/11

4.0	QC8	SECOND CHECK
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⑧

Comment: SECOND CHECK

mmf 08/07/30

⑧

5.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
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Comment: Sub-Contracting OUTSIDE SERVICES
Issue P/O: 0865
Anodize as per Dwg D3299
Possible Supplier: TNM Paint
Material release note is required

08/08/05

⑧

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3299-3* PAR #: NA Fault Category: Machining NCR: Yes No DQA: 1 Date: 08.08.21
D412-706-011 QA: N/C Closed: 1 Date: 08.08.26

NCR: <u>40257</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.07.16	2.0	3 parts scrap. Chunks missing out of the thread. R.C. Crooked insert; tool catching the edge of the thread.	<u>JS1412</u>	Scrap: no-replace. Set-up already removed.		<u>08.07.16</u>	<u>JS1412</u>	<u>08.07.16</u>
08.07.16	2.0	3 parts 0.030" over tolerance on the center, resulting in being 0.030" too long on the total length. R.C. Program: parts were not inspected on the F.A.I., until the order was complete.	<u>JS1412</u>	Revise Program to correct the length. Ensure F.A.I. is always done with the 1st part. parts acceptable per E-mail	<u>08.08.21</u>	<u>8/7/30</u>	<u>JS1412</u>	<u>08.07.16</u>
↓	2.0		<u>JS1412</u>	All parts scrap. <u>Replace B0 M105238</u>	<u>08.07.30</u>	<u>8/7/30</u>	<u>JS1412</u>	<u>08.07.16</u>

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 8:47:06 AM
User: Kim, Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 40257

Part Number: D32993

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

C 08/08/18 (8)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-08-18 (8)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 32

8/8/18

SP

(6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/20

Job Completion



MF 08-08-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	40257
Description: Fitting		Part Number:	D3299-3
Inspection Dwg: D3299	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.00	✓			
Ø0.302	+0.005/-0.000	0.302	✓			
0.550	+/-0.010	.549	✓			
0.63	+/-0.030	.60	✗	x		See Attached E-mail
2.08	+/-0.030	2.11	✓			
0.900		.896	✓			
53°						
0.476	-0.005/+0.000	.473	✓			
MOW for 9/16"-18	Min = 0.5653 Max = 0.573	.5690	✓			
0.200	+/-0.030	.190	✓			
0.450	+/-0.010	.450	✓			
0.10	+/-0.030	.10	✓			
Length of Engagement for 1/4 NPT 0.227	+/-0.010	.230	—			No tool to measure

Measured by:	MME
Date:	08/07/11

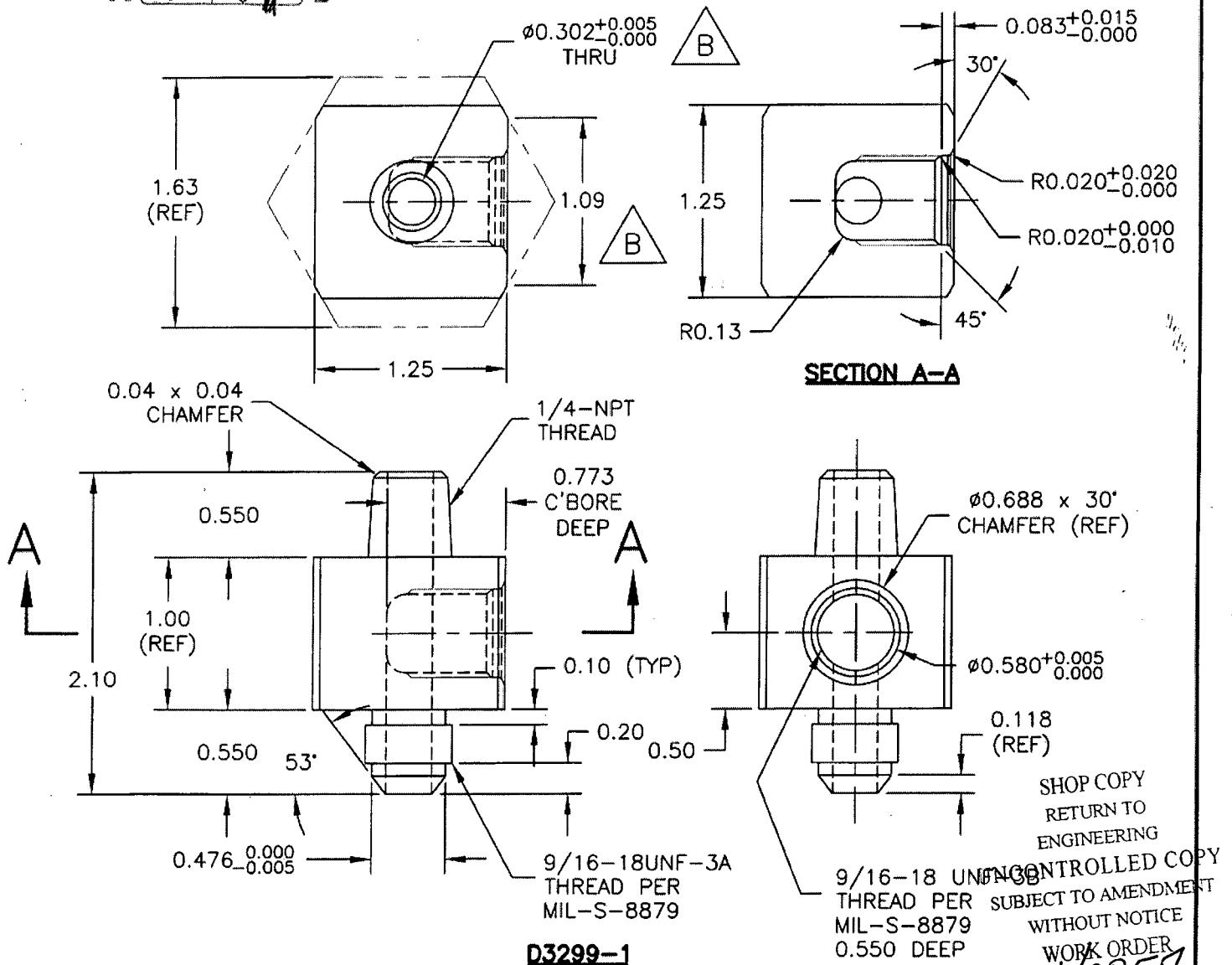
Audited by:	[Signature]
Date:	08/07/30

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.17	New Issue	KJ/JLM	
B	05.05.25	-0.005/+0.000 added to 0.476	KJ/JLM	[Signature]

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 1 OF 3
DATE 05.04.28	TITLE FITTING		SCALE 1:1
A	04.07.06	NEW ISSUE	
B	05.04.28	1.09 WAS 0.837; $\phi 0.302$ WAS $\phi 0.297$	

RELEASED
05-04-28 #**D3299-1 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

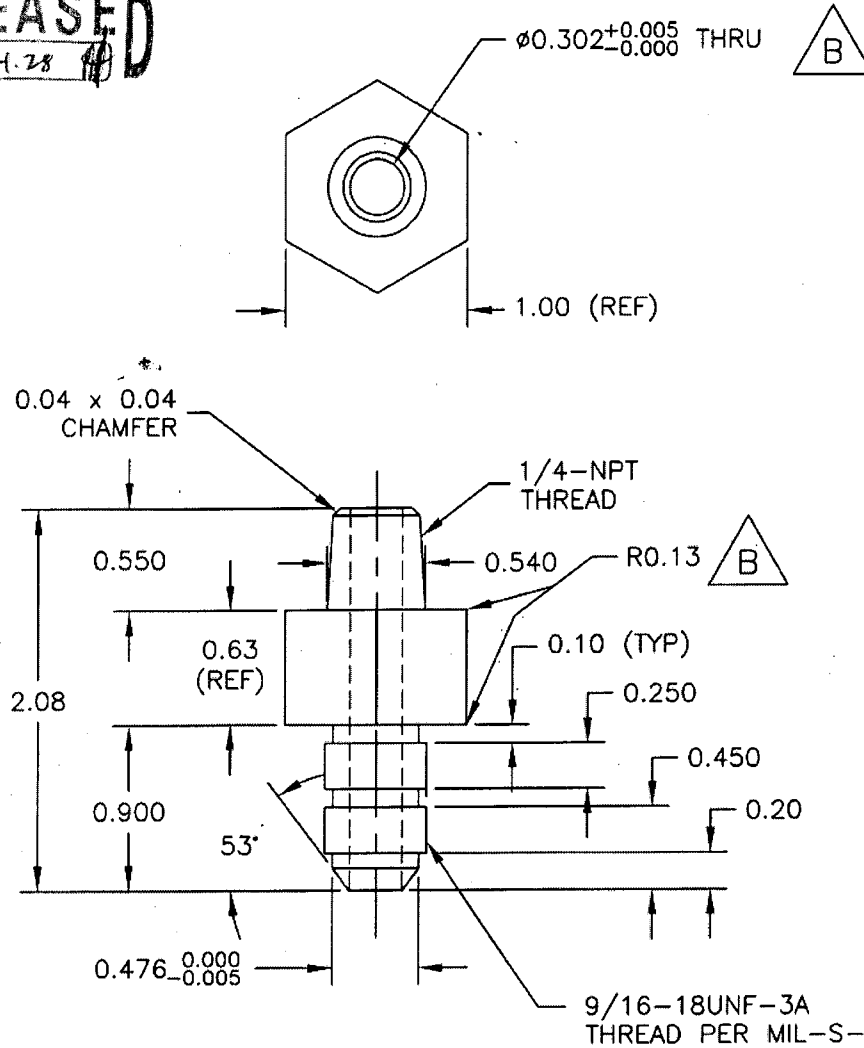
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WORK ORDER
NO. 40257

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 2 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1

RELEASED
05.04.28 #**D3299-3**

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WORK ORDER
NO. 40257

D3299-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

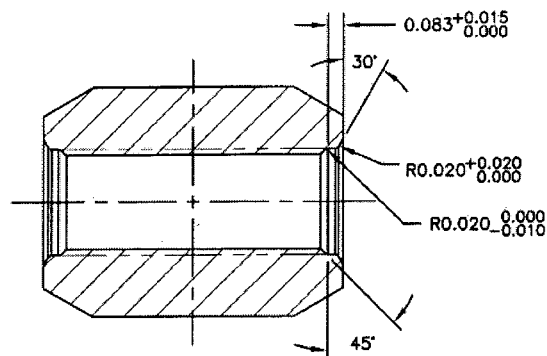
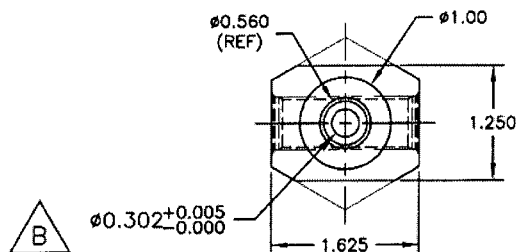
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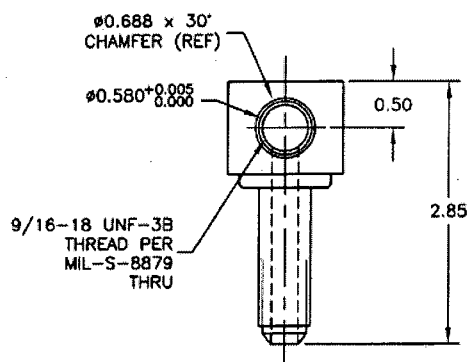
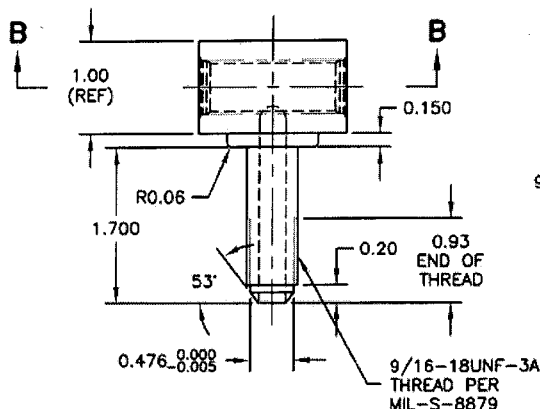


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 3 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:2

RELEASED
05.04.28



SECTION B-B
SCALE 1:1



D3299-5

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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Jason Murdoch

From: Roberto Fuentes [rfuentes@dartaero.com]
Sent: July 16, 2008 9:14 AM
To: 'Jason Murdoch'
Subject: RE: Emailing: CCF15072008_00000

Hi Jason,

Those dimensions doesn't affect function and operation of D3299-3 Fitting in Canister, therefore is acceptable.

Roberto

-----Original Message-----

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: Wednesday, July 16, 2008 5:34 AM
To: 'Roberto Fuentes'
Subject: Emailing: CCF15072008_00000

The message is ready to be sent with the following file or link attachments:

CCF15072008_00000

Note: To protect against computer viruses, e-mail programs may prevent sending or receiving certain types of file attachments. Check your e-mail security settings to determine how attachments are handled.

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified
approuvé NADCAP approved

67086

07-Aug-2008

CLIENT / CUSTOMER:

PART AEROSPACE LTD.

100 ABERDEEN STREET

NEWKESBURY, ONTARIO

SA 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE

NO. DE COMMANDE:
PURCHASE ORDER/

PO00006865



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	6	6	D3299-1 B40301	REV. B BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER
2	8	8	D3299-3 B40257	REV. B BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER
3	4	4	D3299-5 B40302	REV. B BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER

Je certifie que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

Parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager